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DART AEROSPACE LTD	Work Order:	20738
Description: Bracket	Part Number:	D3146-2
Dwg: D3146 Rev. A	Qty:	10
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	KJ	04.04.29	10
2	MV	Cut blanks: 4.500" x 1.250" x 3.100" long Bar Material: 6061-T6/T651 (QQ-A-200/8) 1.250" thick (M6061T6B1.250x04.500) Identify for D3146-2 Batch: B14962	GO	04/05/29	10
3	MV	Machine as per Folio FA419 and Dwg D3146 Identify as D3146-2	SE	04/06/01	10
4	QC2	Inspect parts as they come off the CNC machine	SE	04/06/01	10
5	QC8	Second check	FE	04.06.09	10
6	MV	Deburr and Tumble	FE	04.06.16	10
7	FP	Chemical Conversion Coat as per QSI 005 4.1	MM	04.06.11	10
8	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	MM	04.06.17	10
9	QC3	Inspect Powder Coat	MM	04.06.17	10
10	QC5	Inspect work to Step 9	BE	04.06.17	10
11	ST	Identify and Stock in Spacedoor Cell	Col	04/06/17	10
12	AC	Cost / part 31.68	SAC	04.06.18	10
13	DC	Close W/O 35.21 Inspect Level 21	HJ	04.06.21	10

Rev	Date	Change	Revised By	Approved
A	04.04.28	New issue	KJ/JLM	

RELEASED

04.04.29

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR 20738		WORK ORDER NON-CONFORMANCE D3146-2						
DATE	STEP	Description of NC section A	Corrective Action Section B	Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial					
04/06/01	3	.125 measurement is at .110 - only at one end of part. 3 parts affected	#	ACCEPTABLE THIS TIME ONLY	N/A	B 04.06.01	# 04.06.01	

PAR#: N/A Fault Category: manuf-cnc DQA: ls Date: 04.06.21

QA: N/C Closed: ty Date: 04.06.22

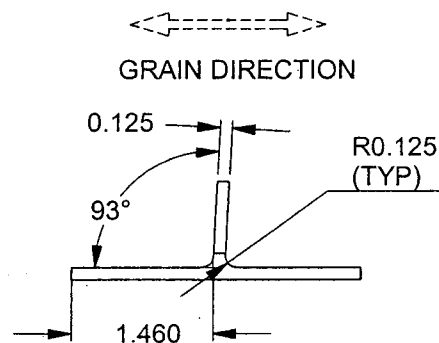
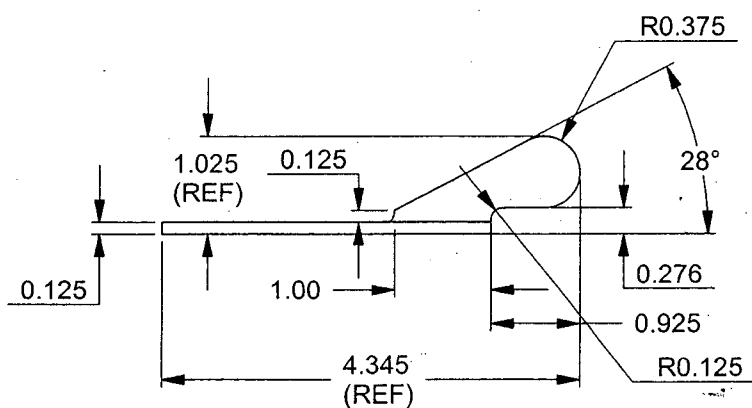
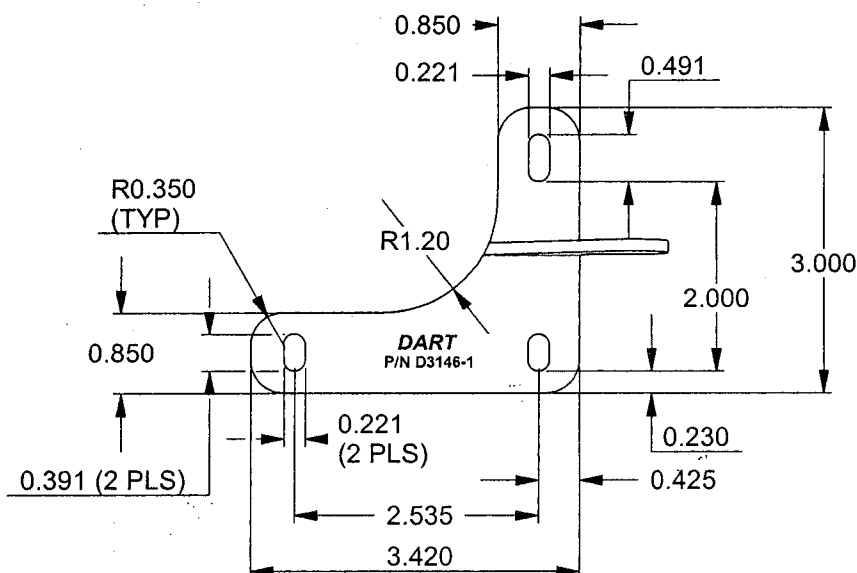
use as is
- acceptable



DESIGN #	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3146	REV. A
DATE 02.04.25	TITLE BRACKET	SHEET 1 OF 1	
A	02.04.25	NEW ISSUE	SCALE 1:2

RELEASED
02.05.27 #

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 20738



D3146-1 BRACKET SHOWN. REPLACES PREMIER P/N B30-23000-27
(D3146-2 BRACKET OPPOSITE. REPLACES PREMIER P/N B30-23000-28)

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR (REF. DART SPEC. M6061T6B)
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N AND LOGO AS SHOWN

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DART AEROSPACE LTD		Work Order:	20738
Description: Bracket		Part Number:	D3146-2
Inspection Dwg: D3146	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.000	+/-0.010	3.002	✓			
2.000	+/-0.010	2.000	✓			
0.230	+/-0.010	0.232	✓			
0.425	+/-0.010	0.422	✓			
3.420	+/-0.010	3.422	✓			
2.535	+/-0.010	2.535	✓			
0.221	+/-0.010	0.220	✓			
0.391	+/-0.010	0.387	✓			
0.221	+/-0.010	0.220	✓			
0.850	+/-0.010	0.850	✓			
R0.350	+/-0.010	0.350	✓			
0.850	+/-0.010	0.848	✓			
0.221	+/-0.010	0.220	✓			
0.491	+/-0.010	0.487	✓			
0.125	+/-0.010	0.110-0.125	✓	✓		
1.025	+/-0.010	1.025	✓			
R0.375	+/-0.010	0.375	✓			
28°	+/-0.1°	28°	✓			
0.276	+/-0.010	0.272	✓			
0.925	+/-0.010	0.925	✓			
R0.125	+/-0.010	0.125	✓			
4.345	+/-0.010	4.348	✓			
0.125	+/-0.010	0.126	✓			
93°	+/-0.1°	93°	✓			
R0.125	+/-0.010	0.125	✓			
Grain Direction	N/A					

PRELIMINARY ISSUE

Measured by:	SP
Date:	04/06/01

Audited by:	EC
Date:	04/06/01

Prototype Approval:	RF
Date:	04-06-01

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Apr 20, 2004
02:46 pm

Work Order No : 0020738
Project Name : D3146-2
Project For : WK420
Work Order Type : Main
Main WO Number :
House Part Number : D3146-2
Description : Hinge Bracket
Manufactured : No
Amount Req'd : ~~0~~ 10
Amount Done : 0
Start Date : 04-20-04
Est Finish Date : 05-10-04
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00